

**GRINDING WHEEL WITH WATER-ABSORPTIVE POLYMER INCLUDED**

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**Abstract**

**PURPOSE:** To heighten the cooling efficiency, lessen the grinding resistance, perform the small pitch cutting or groove forming process effectively, and prolong the lifetime of a whetstone by including abrasive grains in a bonding agent, also including a water-absorptive polymer, and thereby forming intended whetstone.

**CONSTITUTION:** A whetstone is formed by including abrasive grains 2 of diamond, etc., in a bonding agent such as resin bond or the like and also including a water-absorptive polymer 3 such as hydroxy propylcellulose etc., having a low degree of substitution. A cutting blade 1 formed in this manner is structured so that abrasive grains 2 and water-absorptive polymer 3 are attached to the surface, and when a machining agent, etc., is supplied, the polymer 3 moistens - further in case a grinding liquid (aqueous solution of cerium phosphate or silica) including a polish is supplied, particulates 5 of the polish attach to the moistened polymer 3. This permits carrying out an efficient polishing process in good performance.

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